

**Work Order ID 66716**

Page 1

Thursday, February 24, 2011 11:39:54 AM

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11/02/24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**

## Tool ID

## Tool #

**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

Draw Nbr	Revision Nbr								
D3281	Rev E								
DSI 9504	A								

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

x4

Dh.  
11/03/02

Thermoforming Machine

Cut Blanks

105

0.00



Dry Material

HandThermo

Memo

0.00

x4

Dh.  
11/03/02

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:00 AM 11/03/01

Time OUT: 7:00 AM 11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66716**

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Page 2

Item ID: D3281-4L02

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Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

110

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Thermoform

THERMOFORMING MACHINE

0.00

x 4



Thermoforming Machine

Memo

0.00

Thermoform as per Dwg. D3281 and Folio FTA 010  
Dwg. Rev. F  
Folio Rev. D

11/03/02

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

x 4

11/03/02

130



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

x 4

11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID: 66716**

Thursday, February 24, 2011 11:39:55 AM



Page 3

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

140



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC2- Inspect parts off machine FAI/FAIB

0.00

X4

Wk  
11/03/07

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1103108

X4

160



Packaging

Packaging

Packaging

0.00

Memo

0.00

11/3/09 P40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66716**

Thursday, February 24, 2011 11:39:55 AM



Page 4

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

170



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

Memo

0.00

n/3/9 JJ

R11-03-9  
(E)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, February 24, 2011 11:39:59 AM

Page 1

Work Order ID: 66716



Parent Item: D3281-4L02



Parent Item Name: Floor Protector, Aft RH (Black)

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 4.00

Required Qty: 4.00

**Comments:**

IPP Rev:A 04.07.01 New issue KJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

IPP Rev. C

ADd Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-02

Purchased

No

sf 744.3100

17.332

GE PLASTICS LEXAN SHEET



Location

therm

110877

Loc Qty

744.31

744.31

Loc Code

17.332 sq ft

De,  
11/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-719 REV. A  
 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D044-719 REV. 0  
 REF TCCA STC: SH04-40  
 REF FAA STC: SR02051NY  
 REF EASA STC: EASA.IM.R.S.01075

**PURPOSE:**

To add the D044-719-011L08 Clear Cabin Floor Protectors. The -011L08 kit is similar to the existing -011 kit, however the plastic is transparent instead of solid black. The existing D044-719-011 kit will be re-identified as D044-719-011L02.

**CHANGE:**

The D044-719-011L08 Cabin Floor Protectors kit consists of four transparent plastic trays that are placed on the cabin floor to protect the carpets from damage. The -011L08 kit should be installed per the -011 kit of Installation Instructions IIN-D044-719 and maintained per Instructions for Continued Airworthiness ICA-D044-719. The parts list and weight & balance for the -011L08 kit is given below.

**PARTS LIST**

QTY -011L02	QTY -011L08	Part Number	Description
X		D044-719-011L02	Cabin Floor Protectors (Black)
	X	D044-719-011L08	Cabin Floor Protectors (Clear)
1		D3281-1L02	Floor Protector, Fwd LH, Black
	1	D3281-1L08	Floor Protector, Fwd LH, Clear
1		D3281-2L02	Floor Protector, Fwd RH, Black
	1	D3281-2L08	Floor Protector, Fwd RH, Clear
1		D3281-3L02	Floor Protector, Aft LH, Black
	1	D3281-3L08	Floor Protector, Aft LH, Clear
1		D3281-4L02	Floor Protector, Aft RH, Black
	1	D3281-4L08	Floor Protector, Aft RH, Clear
8	8	D2854-1-100	Looped Velcro Strip
8	8	D2854-3-100	Hooked Velcro Strip

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. U4716  
2/11-02-24

**WEIGHT AND BALANCE**

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D044-719-011L02 Cabin Floor Protectors	3.9 lb 1.8 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	195 in-lb 2.3 m-kg
D044-719-011L08 Cabin Floor Protectors	4.4 lb 2.0 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	220 in-lb 2.5 m-kg

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.02.24
CERT. NO.:	SH04-40
ISSUE NO.:	1

A	NEW ISSUE		CP	10.02.24	
REV.	DESCRIPTION			BY	DATE
DESIGN		<u>92</u>	DART AEROSPACE LTD		
DRAWN		<u>92</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED		<u>8</u>	DRAWING NO.		
MFG. APPR.		<u>N/A</u>	REV. A		
APPROVED		<u>#</u>	DSI 9504		
DE APPR.		<u>#</u>	SHEET 1 OF 1		
DATE		10.02.24	TITLE		
			FLOOR PROTECTOR KIT, CLEAR		
			SCALE		
			NTS		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

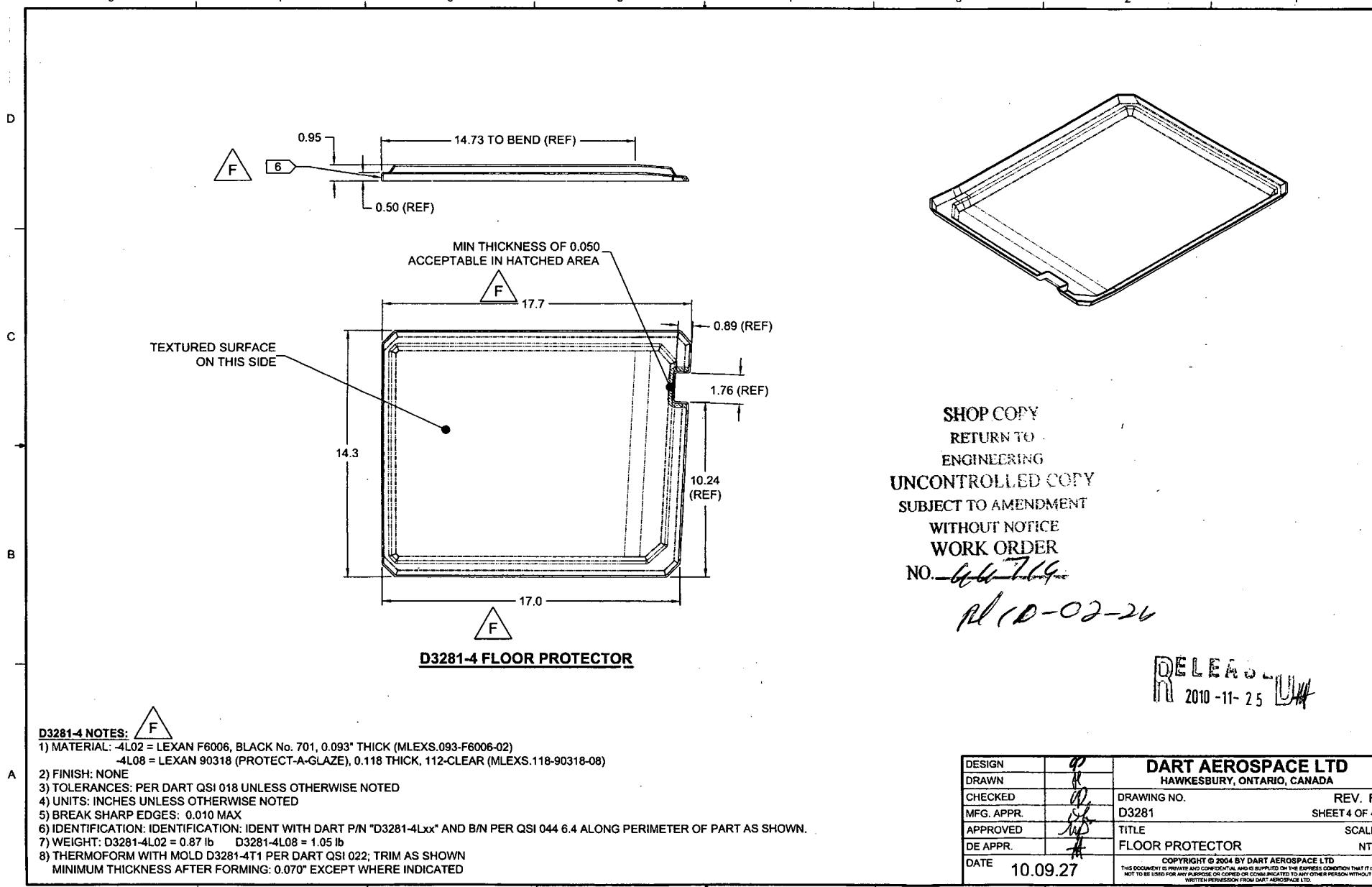
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	<i>Q</i>	DART AEROSPACE LTD
DRAWN	<i>N</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>D</i>	DRAWING NO. <i>D3281</i>
MFG. APPR.	<i>S</i>	REV. F
APPROVED	<i>S</i>	SHEET 4 OF 4
DE APPR.	<i>M</i>	TITLE <i>FLOOR PROTECTOR</i>
DATE	<i>10.09.27</i>	SCALE <i>NTS</i>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66716
Description: Floor Protector, Aft RH	Part Number:	D3281-4
Inspection Dwg: D3281	Rev: E	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

---

**Measured by**

W. H.

Date:

11/02/02

## TRIMMING SECTION

**Measured by:**

Who

Date:

11/03/07

**Audited by:**

三

Date:

11/13/08

---

**Preliminary Approval:**

NA

**Date:**

N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	10.09.01	Dimensions updated per Dwg Rev E	KJ	<i>[Signature]</i> <i>OK</i>